

Work Order ID 68339

Tuesday, April 12, 2011 10:05:33 AM



Page 1

Item ID: D3407-043

Accept



Setup Start



Revision ID:

Item Name: Tow Ring

Stop



Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 110412 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**

Tool ID

Tool

**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

Draw Nbr	Revision Nbr								
D3407	Rev E								

100



Large Fab

Large Fab

Memo

0.00

0.00

Large Fab

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI
004 A/R TIG174 ROD Batch: M101972

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 2

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Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

M116964

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum.

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp1:40
2:40

12X / m / 11/05/10

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

12 BL 11-5-10

150



Packaging

Packaging

Identify as per dwg & Stock Location: 164

0.00

Memo

0.00

11/15/11 SP 120

W/O:		WORK ORDER CHANGES							
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Setup Start



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Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**Accept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

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Picklist Print

Page 1

Tuesday, April 12, 2011 10:05:40 AM

Work Order ID: 68339



Parent Item: D3407-043



Parent Item Name: Tow Ring

Start Date: 4/12/2011

Required Date: 4/18/2011

Comments: IPP Rev:A 05.10.14 New issue KJ/EC

IPP Rev:A 05.10.14 Rev Issue:KJ/EC
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-3  Stem		Manufactured	No	69021 X 12		100	Each	0.0000	1	12		62 11-5-9.	
D3407-5  Ring		Manufactured	No	68561 X 12		100	Each	0.0000	1	12		62 11-5-9.	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

E

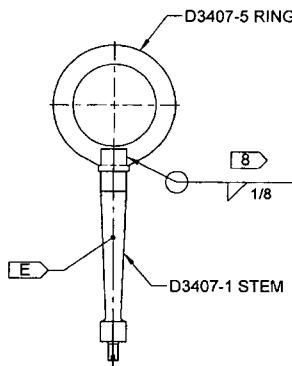
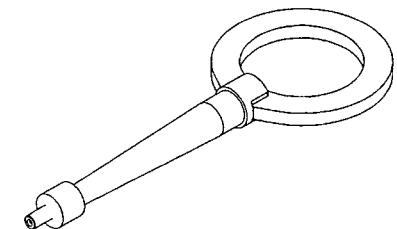
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
X			D3407-043	TOW RING
X			D3407-045	TOW RING
1			D3407-1	STEM
1			D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

SHOP COPY

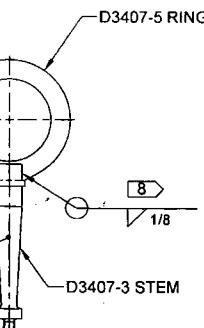
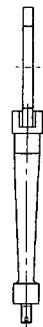
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SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDER

NO. 68339

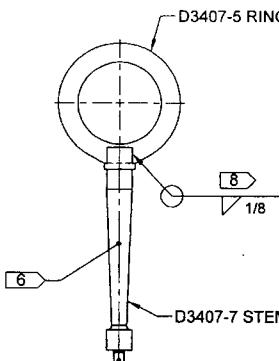
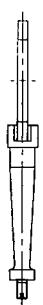
2/11/04/12



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED
02/04/2010

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN B2-1). D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE USA, INC.	
DRAWN	1st	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE PROPERTY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

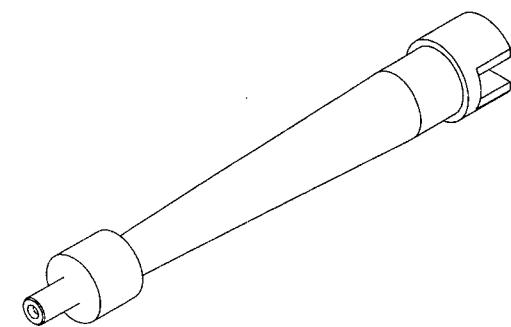
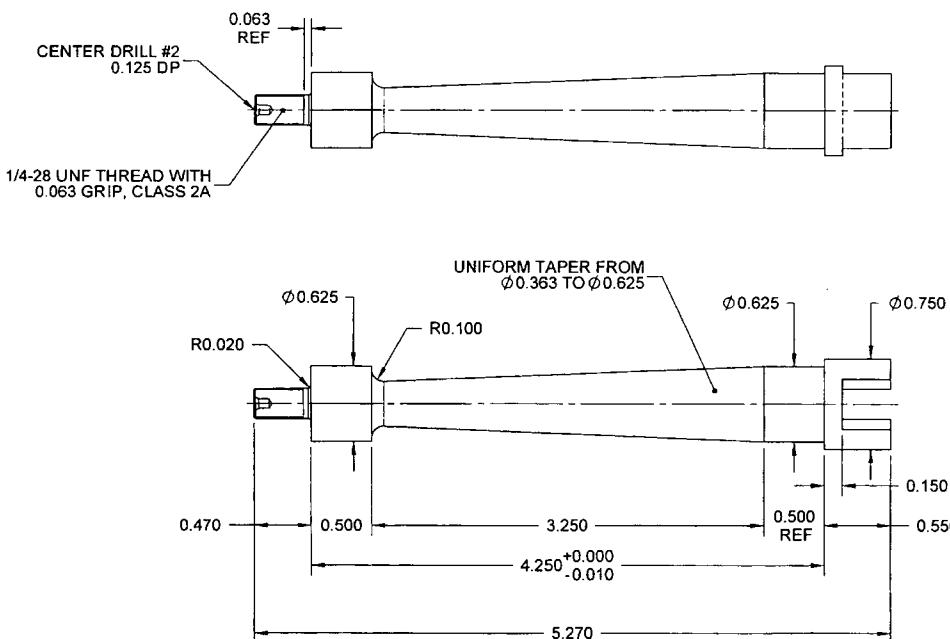
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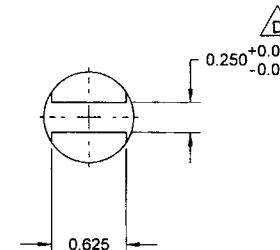
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NOTE: Date & initial all entries



W 68339



D3407-1 STEM

NOTES

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

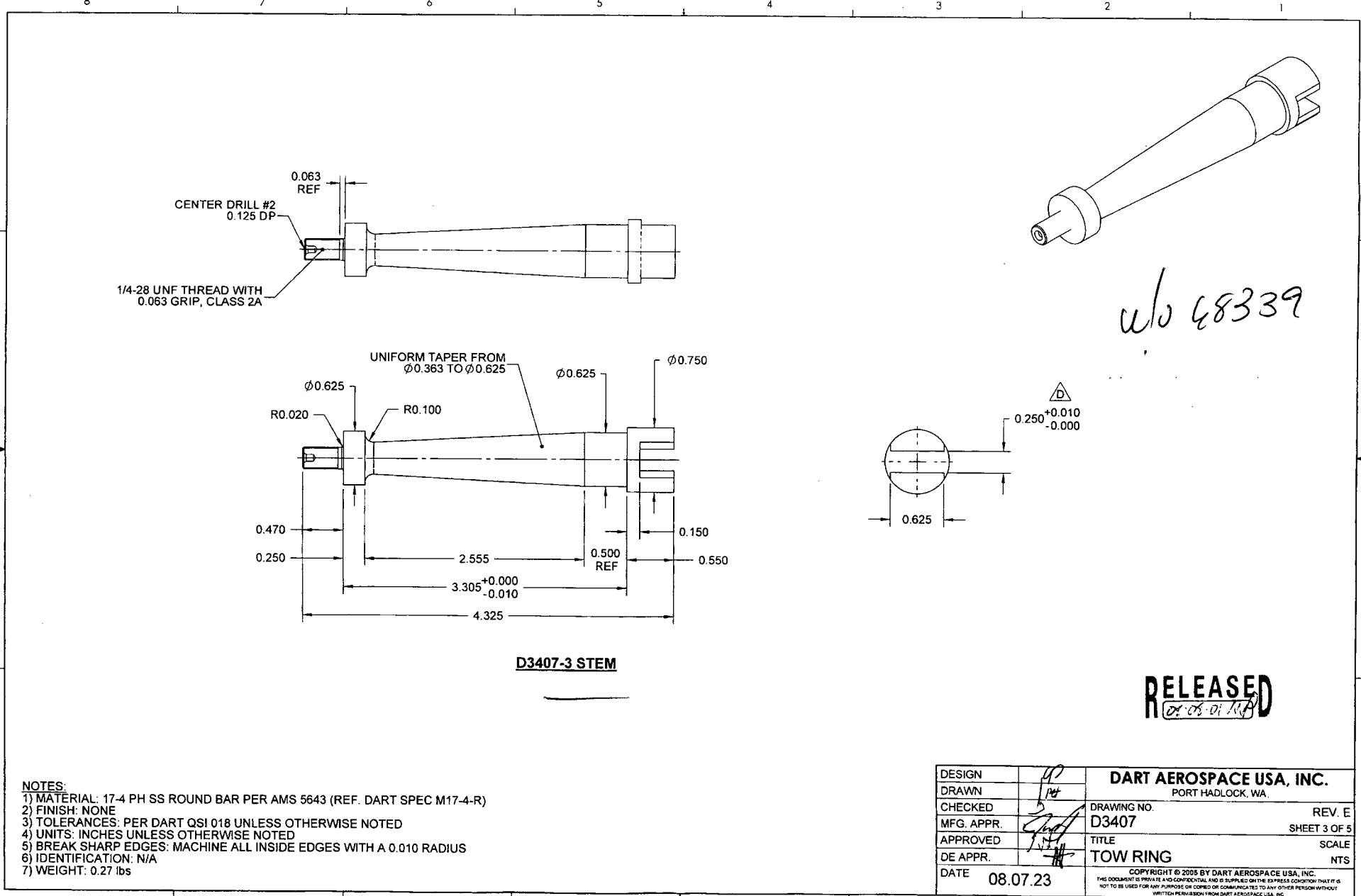
DESIGN	<i>PP</i>	DART AEROSPACE USA, INC.		
DRAWN	<i>PAH</i>	PORT HADLOCK, WA		
CHECKED	<i>✓</i>	DRAWING NO.	REV. E	
MFG. APPR.	<i>CJH</i>	D3407	SHEET 2 OF 5	
APPROVED	<i>WJF</i>	TITLE	SCALE	
DE APPR.	<i>TH</i>	TOW RING	NTS	
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS NOT TO BE COPIED, REPRODUCED, OR OTHERWISE COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

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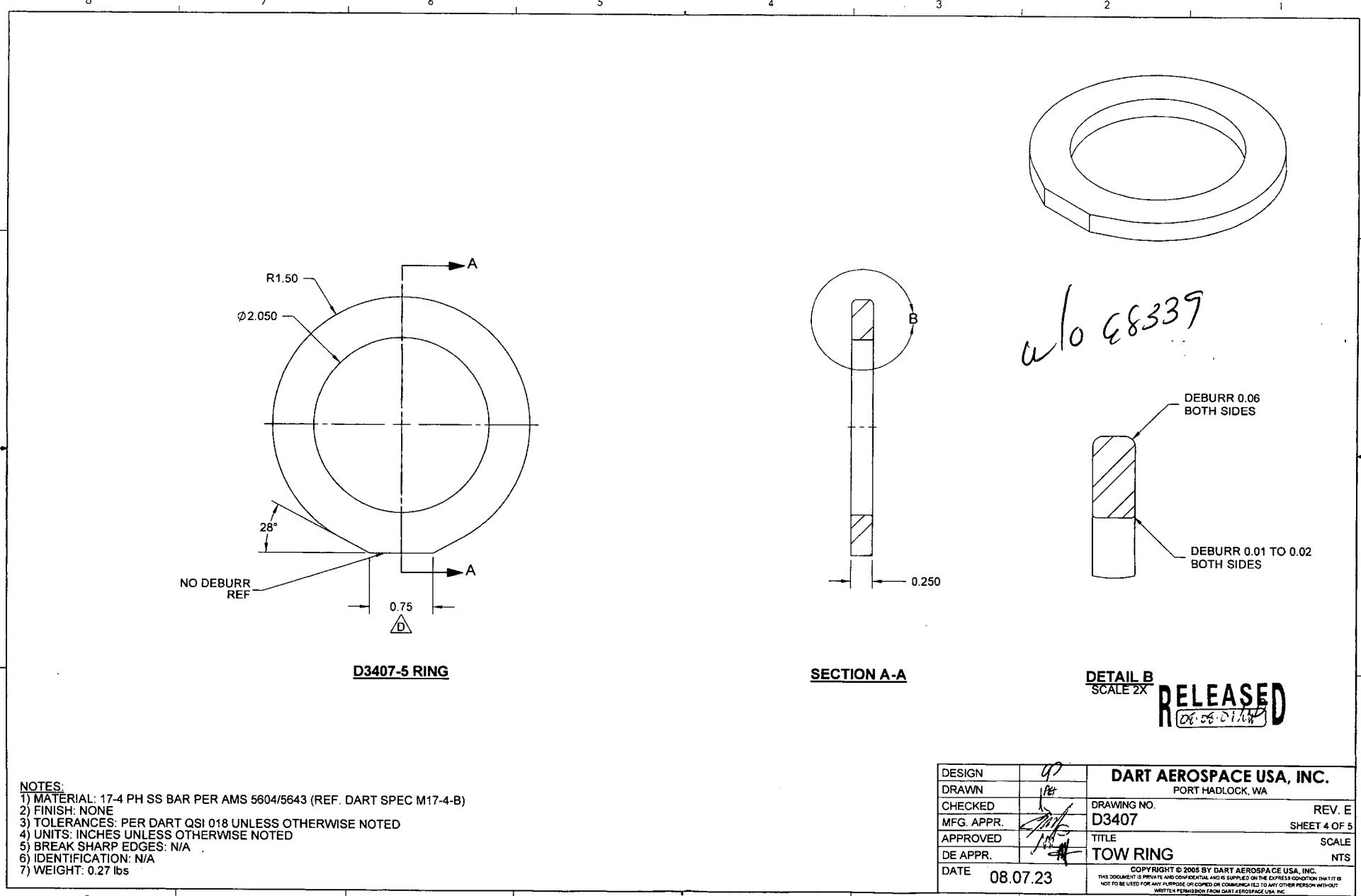


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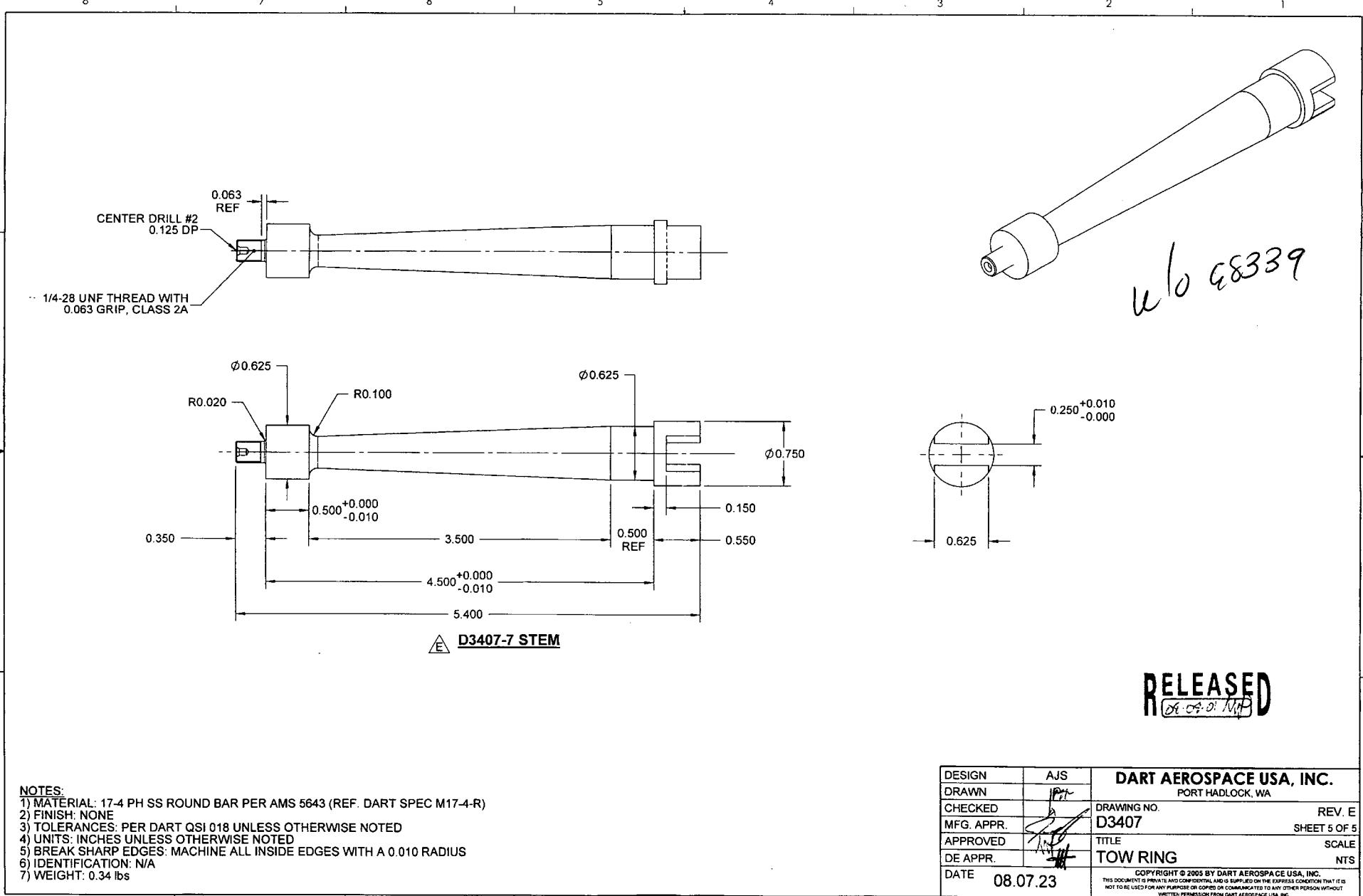


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